

Work Order ID 126974

Wednesday, December 03, 2014 12:50:11 P

126974

Page 1

Item ID: D4640-11 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector
Start Date: 12/18/14 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 12/23/14 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan:  Date: 14-12-03 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4640	D								

100 0.00 ***100*** DAS 23 9-89 14-12-16
Waterjet
FLOW CNC Waterjet
Memo 0.00
***Confirm if parts are trimmed or untrimmed prior to cutting ***

Cut as per dwg
Prog Rev: 0
Dwg Rev: 0

Deburr as required

110 0.00 ***110*** DAS 23 9-89 14-12-16
QC
Quality Control
Memo 0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 38 9-89

120

QC

Quality Control

Memo

USE TEMPLATE TO MARK HOLE LOCATIONS WITH A FINE POINT
MARKER ON TEXTURED SIDE

DEC 18 2014

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

DAS

06

9-89

DEC 18 2014

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

15/1/5 97
AY-12-19

DQA: _____ Date: _____



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Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, December 03, 2014 12:50:11 PM

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Work Order ID: 126974

126974

Parent Item: D4640-11

D4640-11

Parent Item Name: Floor Protector

Start Date: 12/18/14

Required Date: 12/23/14

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	2,486.730	16	84.21053			
MI FXS 093-F6006-07									**	80		DAS	
GE PLASTICS LEXAN SHEET (Grey)												23	14-12-16
												9-89	

Location

Loc Qty

Loc Code

MAT023

2486.73032

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

102.33332

m129471

7.31

m129738

1384.977

129738

DQA: _____ Date: _____



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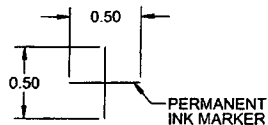
DART AEROSPACE LTD		Work Order:	126975
Description: Floor Protector		Part Number:	D4640-11
Inspection Dwg: D4640 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

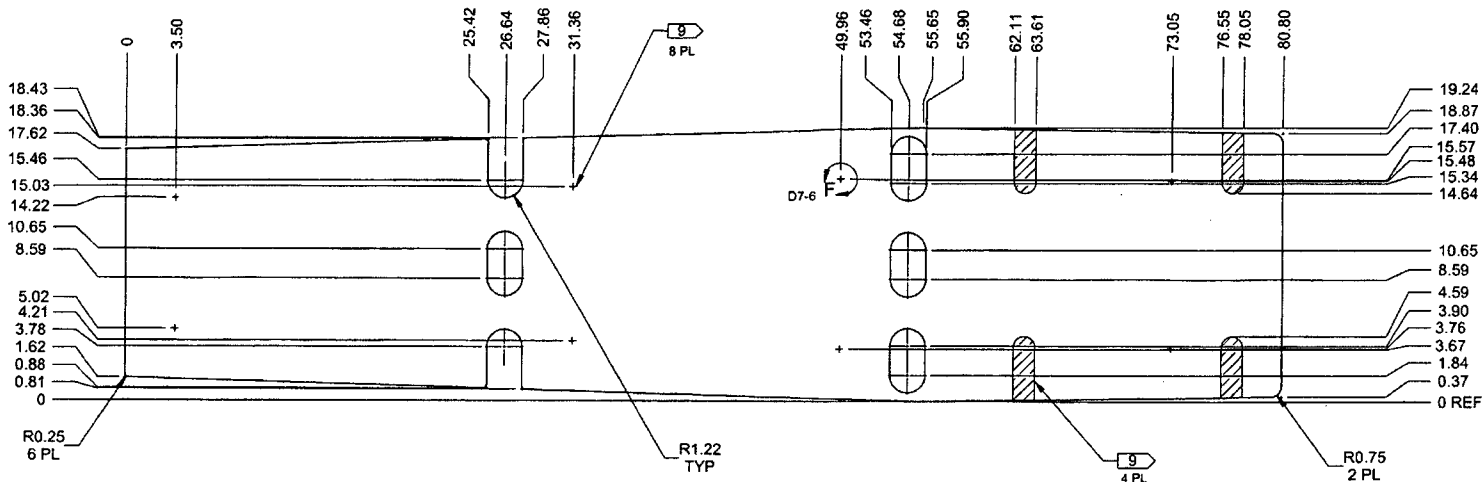
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓		✓	
25.42	+/-0.030	25.40	✓		Qc1-17	
27.86	+/-0.030	27.90	✓		"	
31.36	+/-0.030	31.36	✓		"	
49.96	+/-0.030	49.95	✓		"	
53.46	+/-0.030	53.46	✓		"	
55.90	+/-0.030	55.90	✓		"	
62.11	+/-0.030	62.15	✓		"	
63.61	+/-0.030	63.61	✓		"	
73.08	+/-0.030	73.08	✓		"	
76.55	+/-0.010	76.50	✓		"	
78.05	+/-0.030	78.00	✓		"	
80.80	+/-0.030	80.80	✓		"	
0.88	+/-0.030	0.88	✓		✓	
4.21	+/-0.030	4.20	✓		✓	
5.02	+/-0.030	5.00	✓		✓	
8.59	+/-0.030	8.59	✓		✓	
10.65	+/-0.030	10.65	✓		Qc1-17	
14.22	+/-0.030	14.20	✓		"	
15.03	+/-0.030	15.00	✓		"	
17.62	+/-0.030	17.62	✓		"	
0.37	+/-0.030	0.37	✓		✓	
1.84	+/-0.030	1.84	✓		✓	
3.67	+/-0.030	3.67	✓		✓	
3.76	+/-0.030	3.76	✓		✓	
4.59	+/-0.030	4.59	✓		✓	
8.59	+/-0.030	8.59	✓		✓	
10.65	+/-0.030	10.65	✓		Qc1-17	
14.64	+/-0.030	14.64	✓		"	
15.48	+/-0.030	15.48	✓		"	
15.57	+/-0.030	15.57	✓		"	
17.40	+/-0.030	17.40	✓		"	
18.87	+/-0.030	18.87	✓		"	
19.24	+/-0.030	19.24	✓		"	
0.093	+/-0.010	0.093	✓		✓	

Measured by:	82 SVG	Audited by:	38 9-89	Preliminary Approval:	
Date:	14-12-16	Date:	DEC 18 2014	Date:	

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	



DETAIL F
NOT TO SCALE
TRIMMED KIT ONLY



D4640-11 FLOOR PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2013-01-10

NOTES:

- 1) MATERIAL: F6006-GY5B133 GRAY LEXAN SHEET (SUEDE/POLISHED) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.66 lbs (TRIMMED WEIGHT = 5.55 lbs)
- 8) CHECK PER TEMPLATE DT8929
- 9) IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER:
- DRAW 0.50" CROSS ON TEXTURED SIDE AT INDICATED LOCATIONS USING PERMANENT INK MARKER
- TRIM AND REMOVE SHADED AREA

Handwritten: 4-12-03
126074

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4640	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BAGGAGE PROTECTOR	NTS
DATE	12.12.18	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND OPEN FOR PUBLIC USE. IT IS THE USER'S RESPONSIBILITY TO OBTAIN THE NECESSARY PERMISSIONS FROM DART AEROSPACE LTD.	